

Date: Tuesday, 21/04/2009 4:01:19 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SADDLE
Job Number	: 47350		
Estimate Number	: 12451		
P.O. Number	:	Part Number	: D35001
This Issue	: 21/04/2009 S.O. No. :	Drawing Number	: D3500 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 47119	Material	:
Written By	:	Due Date	: 10/05/2009 Qty: 20 Um: Each
Checked & Approved By	: <u>JLD 09.04.21</u>		
Comment	: Est Rev:A New Issue 06-06-15 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 6061-T6 7.0x6.5x2.0  
 350 Saddle Billet  
 Batch: B 46414

21  
09/06/05

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 47350 Double check by: DJP

- 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets
- 4-Deburr
- 5-Tumble to remove sharp edges.

DJP 09/06/06 20

P40 →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE...

DJP 09/06/06 20

4.0	QC8	SECOND CHECK
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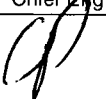

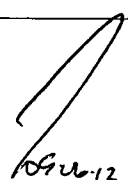

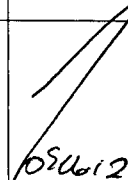


Comment: SECOND CHECK

09/06/08 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3500-1 PAR #: N/A Fault Category: Prod / Machine NCR: Yes No DQA: 1D Date: 09/06/12  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1D Date: 09/06/12

NCR: <u>47350</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/05	2.0	origin off on x axis by .500 rougher removed too much material. R.C. op error	 09.06.05 per 09/06/12	Scrap & replace B46414	 09/06/05	 09.06.12	 09.06.05 per 09/06/12	 09.06.12

NOTE: Date & initial all entries

Date: Tuesday, 21/04/2009 4:01:19 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 47350

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HP 09-06-10

6.0

POWDER COATING

POWDER COATING



M 111472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:15am

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:45am

HP 09-06-11 K2C

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(20)

Comment: INSPECT POWDER COAT

BR 09-06-11

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(20x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

429 9/6/11

sep

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47350
<b>Description: Saddle</b>		<b>Part Number:</b> D3500-1
<b>Inspection Dwg: D3500 Rev: C</b>		<b>Page 1 of 1</b>

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
I	R1.575	R1.595		1.5885	1.591	1.5905	1.586		
J	0.240	0.260		0.252	0.245	0.246	0.244		
K	0.490	0.510		0.499	0.499	0.499	0.499		
L	3.590	3.650		3.600	3.600	3.620	3.620		
M	0.315	0.322		0.316	0.322	0.322	0.322		
N	0.256	0.262		0.257	0.259	0.258	0.258		
O	6.500	6.520		6.511	6.512	6.512	6.510		
P	5.990	6.010		5.996	5.995	5.996	5.995		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.548	0.544	0.546	0.545		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.045	0.045	0.045	0.045		
Y	0.100	0.120		0.110	0.110	0.110	0.108		
AA	R1.125	R1.145		1.137	1.134	1.136	1.1365		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.250	0.253	0.253	0.255		
AE	1.810	1.830		1.821	1.820	1.820	1.820		
AF	0.240	0.260		0.248	0.250	0.250	0.250		
AG	0.140	0.160		0.148	0.150	0.147	0.149		
AH	0.140	0.160		0.148	0.148	0.150	0.148		
AI	0.140	0.160		0.153	0.153	0.155	0.154		
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 09/06/06

Audited by: <i>[Signature]</i>
Date: 09/06/08

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	147350
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		0.486	.486	0.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.373	0.373	.373	.373		
F	0.490	0.510		.500	0.500	0.500	0.500		
H									
I	R1.575	R1.595		1.581	1.587	1.581	1.590		
J	0.240	0.260		0.243	0.244	0.246	.246		
K	0.490	0.510		0.499	0.499	0.499	.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.322	0.322	.322	.322		
N	0.256	0.262		0.258	0.258	.258	.258		
O	6.500	6.520		6.512	6.512	6.514	6.513		
P	5.990	6.010		5.996	5.996	5.996	5.997		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.544	0.5445	0.5445	0.544		
V	0.793	0.803		0.798	.798	.798	.798		
W	R.240	R.260		0.250	.250	.250	.250		
X	0.040	0.060		0.045	0.045	0.045	0.045		
Y	0.100	0.120		0.100	0.100	0.100	0.100		
AA	R1.125	R1.145		1.1355	1.134	1.1345	1.137		
AB	R.490	R.510		0.500	.500	.500	.500		
AC	0.615	0.635		0.630	.630	.630	.630		
AD	0.240	0.260		0.254	0.255	0.255	0.254		
AE	1.810	1.830		1.820	1.819	1.819	1.822		
AF	0.240	0.260		0.248	0.248	0.249	0.250		
AG	0.140	0.160		0.147	0.147	0.148	0.150		
AH	0.140	0.160		0.1525	0.150	0.150	0.148		
AI	0.140	0.160		0.155	0.154	0.154	.155		
Accept/Reject									

Measured by:	DS
Date:	09/06/06

Audited by:	mf
Date:	09/06/08

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	47350
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	110	12		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.374	0.374	0.374	.374		
F	0.490	0.510		0.500	0.498	0.499	0.499		
H									
I	R1.575	R1.595		1.586	1.580	1.585	1.586		
J	0.240	0.260		0.244	.2445	.243	0.245		
K	0.490	0.510		0.499	0.499	0.499	0.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.322	.322	.322	.322		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		5.996	5.996	5.996	5.996		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.544	.5438	0.545	0.543		
V	0.793	0.803		0.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		0.045	0.045	0.045	0.045		
Y	0.100	0.120		0.100	0.100	0.100	0.100		
AA	R1.125	R1.145		1.1345	1.134	1.1355	1.1355		
AB	R.490	R.510		.500	0.500	.500	.500		
AC	0.615	0.635		.630	0.630	.630	.630		
AD	0.240	0.260		0.254	0.255	0.255	0.254		
AE	1.810	1.830		1.820	1.819	1.819	1.818		
AF	0.240	0.260		.248	0.247	0.250	.248		
AG	0.140	0.160		0.148	0.146	.149	0.147		
AH	0.140	0.160		0.150	0.149	0.148	0.150		
AI	0.140	0.160		0.155	0.154	0.155	0.154		
Accept/Reject									

Measured by:	JIP
Date:	09/06/07

Audited by:	SWK
Date:	09/06/08

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	47350
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>		<b>Rev: C</b>	<b>Page 1 of 1</b>

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13	14	15	16		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.373	0.373	0.373	0.373		
F	0.490	0.510		0.501	0.500	0.500	0.500		
H									
I	R1.575	R1.595		1.585	1.584	1.584	1.580		
J	0.240	0.260		0.245	0.245	0.248	0.245		
K	0.490	0.510		0.499	0.499	0.499	0.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.322	.322	0.322	0.322		
N	0.256	0.262		.258	.258	0.258	0.258		
O	6.500	6.520		6.513	6.512	6.512	6.512		
P	5.990	6.010		5.996	5.996	5.996	5.996		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.543	0.543	0.543	0.544		
V	0.793	0.803		.798	.798	0.798	0.798		
W	R.240	R.260		.250	.250	0.250	0.250		
X	0.040	0.060		0.045	0.045	0.045	0.050		
Y	0.100	0.120		0.100	0.100	0.100	0.100		
AA	R1.125	R1.145		1.1355	1.1355	1.132	1.1325		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	0.630	0.630		
AD	0.240	0.260		0.255	0.255	0.256	0.256		
AE	1.810	1.830		1.820	1.818	1.818	1.818		
AF	0.240	0.260		0.248	0.247	0.248	0.248		
AG	0.140	0.160		0.148	0.147	0.147	0.147		
AH	0.140	0.160		0.148	0.148	0.149	0.151		
AI	0.140	0.160		0.154	0.152	0.158	0.156		
Accept/Reject									

Measured by:	DJP
Date:	09/06/07

Audited by:	mlf
Date:	09/06/08

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	47350
<b>Description:</b> Saddle		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.483	0.490		.486	0.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.373	0.374	0.373	0.373		
F	0.490	0.510		0.4985	0.500	0.499	0.500		
H									
I	R1.575	R1.595		1.582	1.581	1.580	1.583		
J	0.240	0.260		0.244	0.244	0.244	0.243		
K	0.490	0.510		0.499	0.499	0.499	0.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.322	0.322	0.322	.322		
N	0.256	0.262		0.258	0.258	.258	.258		
O	6.500	6.520		6.512	6.513	6.513	6.513		
P	5.990	6.010		5.996	5.997	5.993	5.994		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.543	0.543	0.542	0.543		
V	0.793	0.803		0.798	0.798	.798	.798		
W	R.240	R.260		0.250	0.250	.250	.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.100	0.100	0.100	0.100		
AA	R1.125	R1.145		1.135	1.134	1.134	1.136		
AB	R.490	R.510		.500	0.500	.500	.500		
AC	0.615	0.635		0.629	0.630	0.630	0.630		
AD	0.240	0.260		0.253	0.254	0.253	0.253		
AE	1.810	1.830		1.819	1.8185	1.818	1.820		
AF	0.240	0.260		0.250	0.249	0.247	0.249		
AG	0.140	0.160		0.148	0.1465	0.146	0.149		
AH	0.140	0.160		0.146	0.148	0.149	0.148		
AI	0.140	0.160		0.154	0.153	0.157	0.154		
Accept/Reject									

Measured by:	DJP
Date:	09/06/10

Audited by:	mf
Date:	09/06/10

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	

